

Work Order ID 75263

75263

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October-19-11 3:21:41 PM

Item ID: D2521 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw 205
 Start Date: 19/10/2011 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 07/11/2011 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/10/19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2521	Rev J								

120
120 FLOW WATER JET 0.00
 Waterjet Memo 0.00
 FLOW CNC Waterjet Cut Blank as per D2521 blank file

B11-11-1

(16)

130
130 HAAS CNC VERTICAL MACHINING #1 0.00
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1
 1-Inspect material for defects or damage prior to machining
 2-Machine as per Folio and Dwg D2521 Identify as D2521
 3-Deburr

F.K. 11/11/29

16

140
140 QC2- Inspect parts off machine FAI/FAIB 0.00
 QC Memo 0.00
 Quality Control

F.K. 11/11/29

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		Re N. 12-3		16			
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: PPP 75213. Memo	0.00 0.00				16x		SP 11-12-05.	
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						n 11/2/50	

MF 11-12-05

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Picklist Print

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Work Order ID: 75263

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Parent Item: D2521

D2521

Parent Item Name: Bearpaw 205

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 08-10-01 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

sf

745.6200

117.8947

MUHMWB10

B11-11-1

UHMW 1" Black

Location

Loc Qty

Loc Code

MAT018

645.62

117321

74.6

117738

124.3

117819

99.3

118257

27.42

119145

320

ST

100

118814

100

119143

(16)

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DART AEROSPACE LTD		Work Order:	75263
Description: Bearpaw		Part Number:	D2521
Inspection Dwg: D2521 Rev: J		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	.260	✓		FK-04	Vern.
B	0.90	0.96	.925	✓		FK-04	"
C	0.27	0.330	.307	✓		FK-06	Depth gauge
D	0.470	0.530	.500	✓		FK-04	Vern.
E	21.740	21.760	21.750	✓		FK-05	Tape.
F	0.72	0.780	.751	✓		FK-04	Vern.
G	0.35	0.410	.377	✓		"	"
H	11.490	11.570	11.500	✓		FK-05	Tape
I	3.41	3.47	3.433	✓		FK-04	Vern
J	11.790	11.810	11.800	✓		FK-05	Tape.
K	9.47	9.53	9.50	✓		"	"
L	7.190	7.210	7.200	✓		"	"
M	6.910	6.970	6.94	✓		"	"
N	44.47	44.530	44.50	✓		"	"
O	6.590	6.650	6.625	✓		"	"
P	0.940	0.980	.952	✓		FK-04	Vern.
Q	18.97	19.03	19.000	✓		FK-05	Tape.
R	0.350	0.410	.380	✓		FK-04	Vern.
S	0.740	0.780	.750	✓		"	"
T	0.240	0.280	.251	✓		"	"
U	0.370	0.410	.38	✓		FK-06	Depth gauge
V	0.740	0.780	.750	✓		FK-04	Vern.
W	0.740	0.780	.755	✓		"	"

Measured by: F.K.	Audited by: Rq	Prototype Approval:	N/A
Date: 11/11/29	Date: 11.12.3	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM	

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NOTE: Date & initial all entries



DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED #	DRAWING NO. D2521	REV. J SHEET 1 OF 3
DATE 06.07.28		TITLE 205 BEARPAW	SCALE NTS
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

11/10/19
NO. 4263 H.L.T.
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP COPY

RELEASED

06 08 23 #

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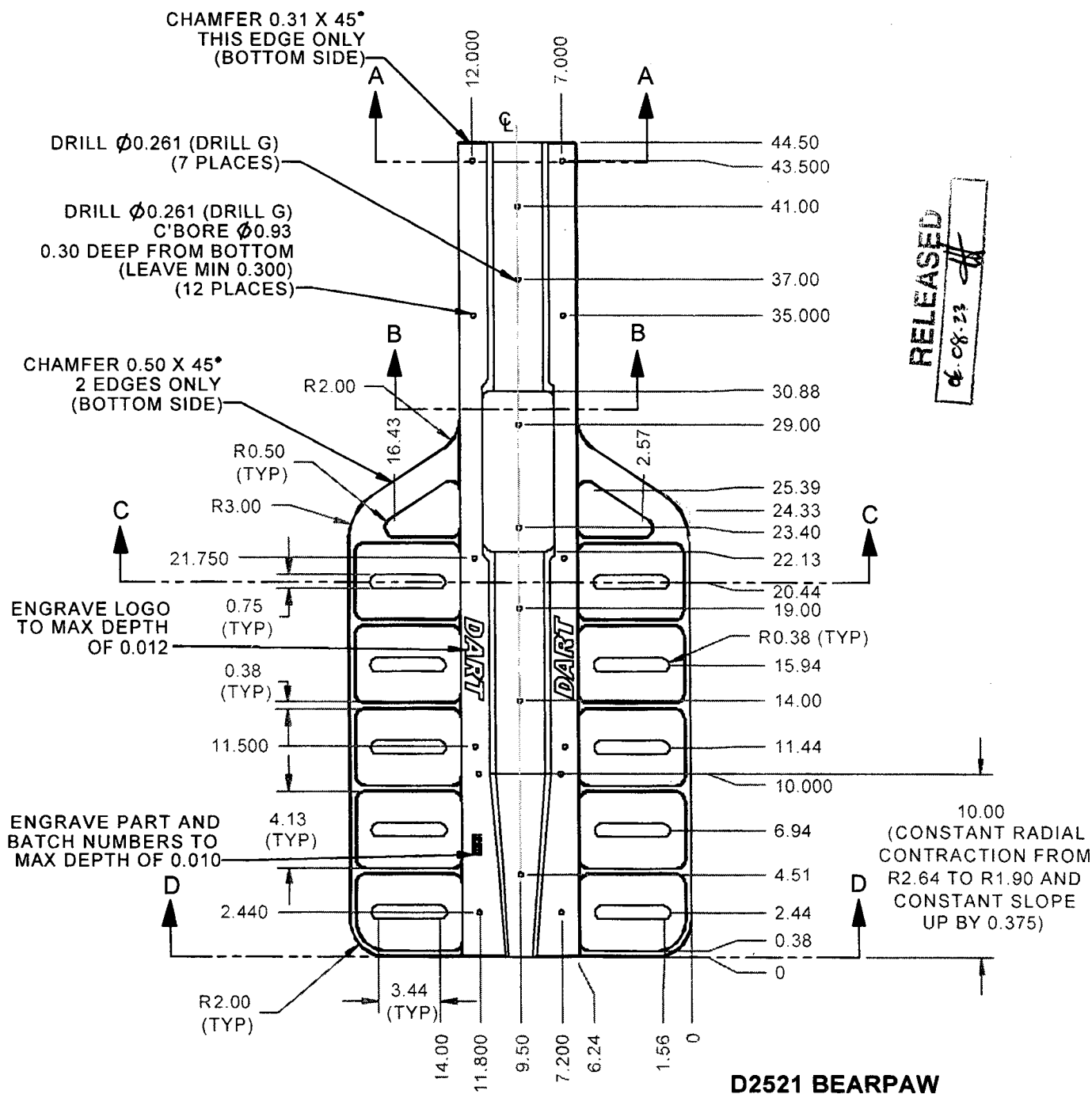
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. J
		D2521	SHEET 2 OF 3
DATE		TITLE	SCALE
06.07.28		205 BEARPAW	1:8



NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT \varnothing

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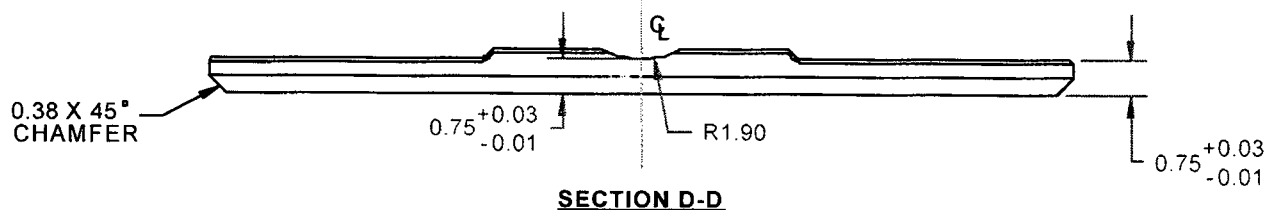
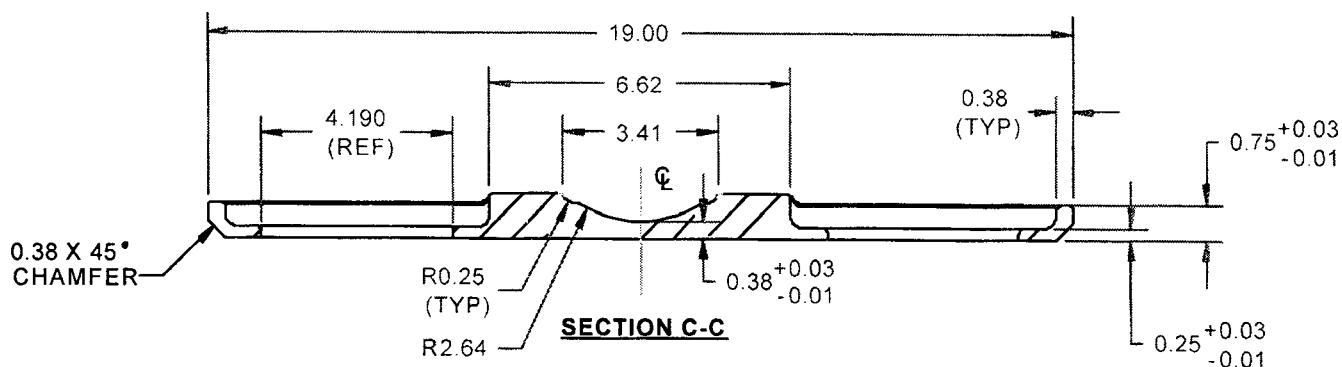
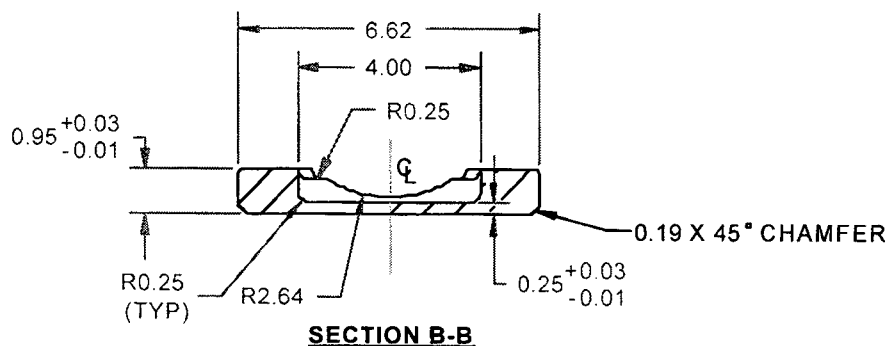
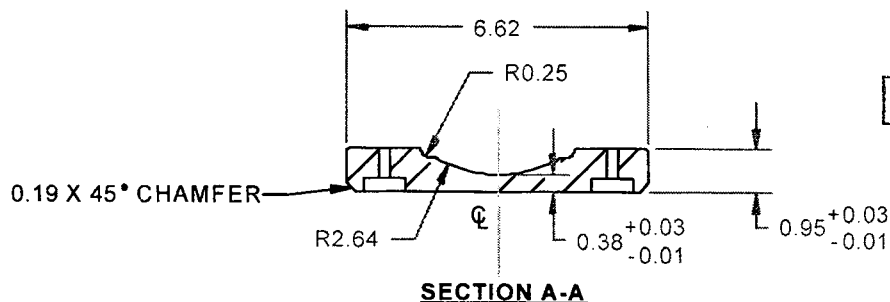
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CHECKED UP	APPROVED [Signature]	DRAWING NO. D2521	REV. J
DATE 06.07.28	TITLE 205 BEARPAW	SHEET 3 OF 3	
		SCALE 1:4	



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